Work Orde: January-30-14 1	r ID 112243 1:20:27 AM	D 3	535-23	*112	2243*						Page 1
Revision ID:	D3535-23 Stainless Steel Wearpla		12243	Accept	*N900	040	100)* s	Setup Star Stop		S1* S2*
Start Date: 1 Required Date: 1 Reference:		Qty: 5.00 Qty: 5.00	*5* *5*	*6*	Cust Item 1 Customer:	ID:					
Approvals:	Process Plan:	ALJ	Date:			ate:		I	Run Star Sto _l	/ 	R1* R2*
Sequence ID/ Work Center ID	Operat Descri			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Na	or		, I							
D3535	Rev B										
*1 \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\	·	WATER JET Memo 1-Cut as per Deburr if nec		0.00 0.00 v: \$\ \text{Prog Rev:} \	B _2-			6	0		Ae 14.02.19
110 _{24.} *110* QC	QC2- In	spect parts off ma	achine FAI/FAIB	0.00 يعير · 0.00	, .			6			Ae 14,02.1
120 *1 20* QC Quality Control	QC8- In	spect parts - seco	nd check	0.00 DAS 0.00 27 0.00 Y	13			<u>`</u>			·

DQA:			Date:											•	
						WORK ORDER NON	-CC	ONFO	RMANCE / U						AEROSPACE
QA Closed:			Date:								Wo	ork Order up	date only		
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	-					Rework	1		Skid-tube	Crosstube			Water Jet	\Box	Engineering
Part N	lo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		Quality
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NCR N	۱o. ₋					Suspected Unapproved] !	:	Large Fab	Composite			Supplier		
Root					Desci	ription of work order update	1	nitial	Ac	tion		Sign &			
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		Cracks				Broken/Damage/Defect		Hardwa	are			Part Incorred	-		Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs	Г	Inspect	ion Incomplete/U	nqualified		Part Lost/Mi	ssing	-	Weld
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		Crushing	——————————————————————————————————————		Countersink		Misali	gned/off center			Positioned V	_			
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		Turning S	equence			Finish		Out of	Calibration						
		Wave/Twist in Tube				Fit/Function		Out of	Sequence						

Work Order ID 112243

112243

Page 2

January-30-14 11:20:27 AM Item ID: D3535-23 Accept *N900040100* Setup Start **Revision ID:** Stainless Steel Wearplate Center Fwd **Item Name: Start Date:** 1/31/14 Start Qty: 5.00 **Cust Item ID:** Required Date: 1/31/14 Req'd Qty: 5.00 **Customer:** Reference: Run Process Plan: _____ Date: _____ **Tooling: Approvals:** Date: Stop Date: SPC (Y/N): Date: Sequence ID/ **Operation** Set Up/ Tool ID Tool# Plan Accept Reject Reject Insp. **Work Center ID Description Run Hours** Code Qty Qty Number Stamp 130 0.00 NC BRAKE *130* DAS Brake NC 0.00 Memo 30 9-89 Brake NC 1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT83262-Form joggle as per Dwg D3535 using Jig DT81583-Identify as D3535-23 DAS 140 QC5- Inspect part completeness to step on W/O 0.00 *140* OC Memo Quality Control Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 150 0.006 \$ H-2-18. *150* Powdercoat Memo Powder Coating

DQA:			Date:			WORK ORDER NON	cc	NIFO!	DNAANCE / LI	DDATE						
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Work Ord January-30-14	ler ID 11224 11:20:27 AM	3		*112					Page 3			
Item ID: Revision ID: Item Name:	D3535-23 Stainless Steel Wea	rplate Center Fwd		Accept	*N900	<u>)</u> 040	100) * ⁵	Setup	Start Stop	*N *N	S1* S2*
Start Date: Required Date Reference:		eq'd Qty: 5.00	*5* *5*		Cust Item Customer					Q. .		
Approvals:	Process Plan: QC:	Tooling: SPC (Y/N):		Date: Date:]	Run	Start Stop	*N	R1*		
Sequence ID/ Work Center I 160 *160* QC Quality Control	ID Des	eration scription 3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00 0.00	Tool ID 8 7 89 2 . 19	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
170 *17 Packaging Packaging	Iden	ntify as per dwg & Stoo Memo	ck Location: FP-0	0.00				<u>x</u> 6	, 	<u> </u>	Isl	Worls

QC21- Final Inspection - Work Order Release

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Quality Control

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Memo

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MLJ 14-02-19 MLJ 14-02-19

DQA:			Date:									DART		
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		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorrect		Tem	perature/Cure
		Crimp/Kir	k/Ripple	/Wave		Burrs		Inspect	tion Incomplete/Unqualified		Part Lost/Miss	ing	Weld	d .
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		Turning S	equence			Finish		Out of	Calibration					
		Wave/Twist in Tube				Fit/Function		Out of	Sequence					

January-30-14 11:20:26 AM

Work Order ID:

112243

Parent Item:

D3535-23

Parent Item Name:

Stainless Steel Wearplate Center Fwd

Start Date: 1/31/14

Required Date: 1/31/14

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 304/316 .040 Sheet		Purchased	No			100	sf	188.5500	1.3615	7.1657895	Ae	- 14.	02.1
304/310 .040 Sheet				Location		Loc Oty	<u>Lo</u>	c Code					
				MAT020		188.55							
				m1268	852	3.55						1 2	
				m1274	454	185			12	<u>.745</u> 4 "	> -	1	

DQA:			Date:										TRACT
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i	•					Rework	1		Skid-tube Crosst	ube		Water Jet	Engineering
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		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred		Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
		Cuffs				Contamination		Instruc	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center		Positioned V		_
		Heat Trea	nt			Cut Too Short		Mislab	eled		Power Loss/	Surge	Other
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		Marks/Ch	atter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of	Calibration				
		Wave/Twist in Tube				Fit/Function		Out of	Sequence				

DART AEROSPACE LTD	Work Order: 1/2243	2
Description: Wearshoe	Part Number: D3535-23	
Inspection Dwg: D3535 Rev: B	Page 1 of	1

FIRST ARTICLE INSPECTION CHECKLIST

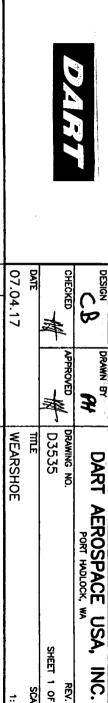
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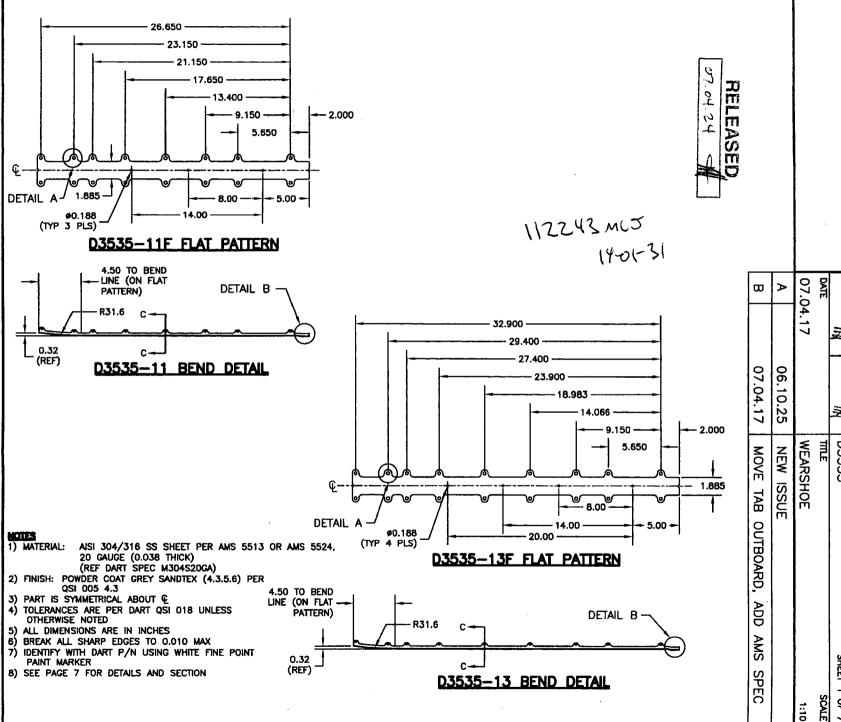
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Measured by: Ac Audited by: 27 Prototype Approval: N/A

Date: 14.02.18 Date: 14.02.18 Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	<i>M</i>
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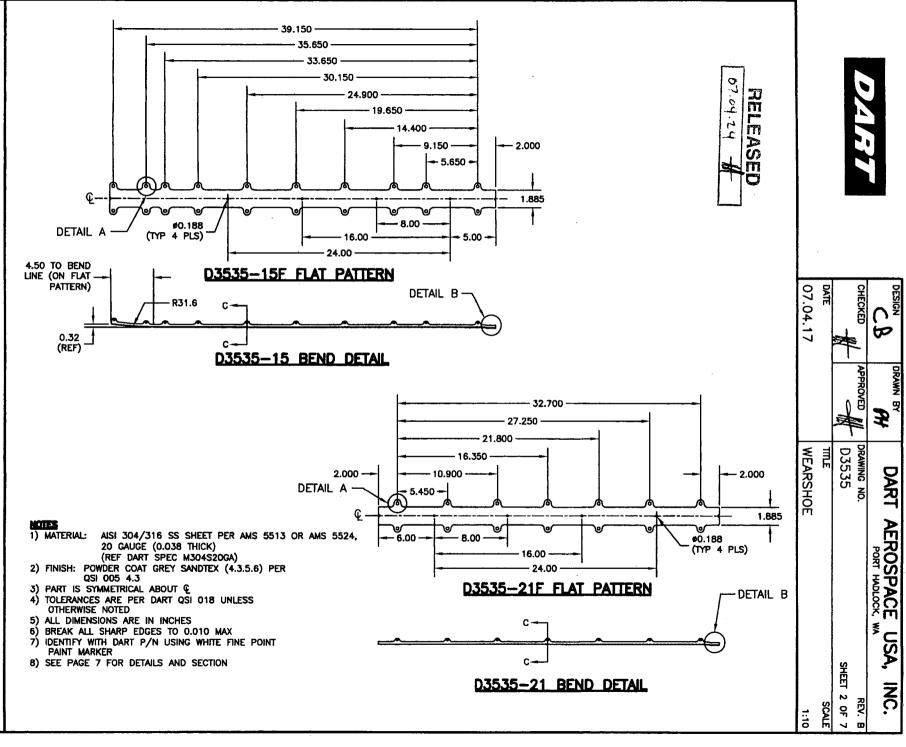
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PURPOSE

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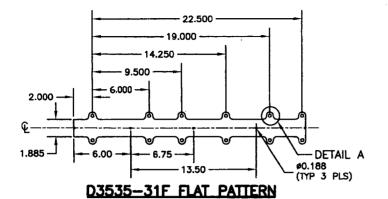
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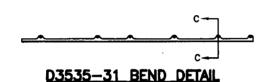
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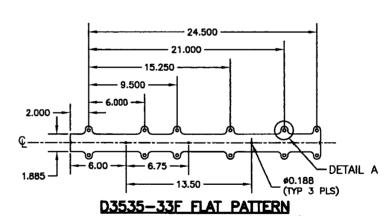
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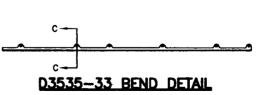
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NO.	// DRAWING NO.	APPROVED ill	CHECKED //	
PORT HADLOCK, WA		#	80°	







- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
- (REF DART SPEC M304S20GA) 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT &
 4) TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



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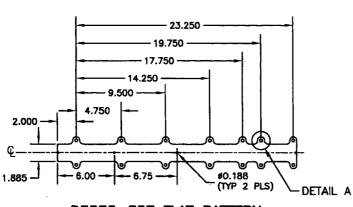
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WEARSHOE

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D3535-35F FLAT PATTERN



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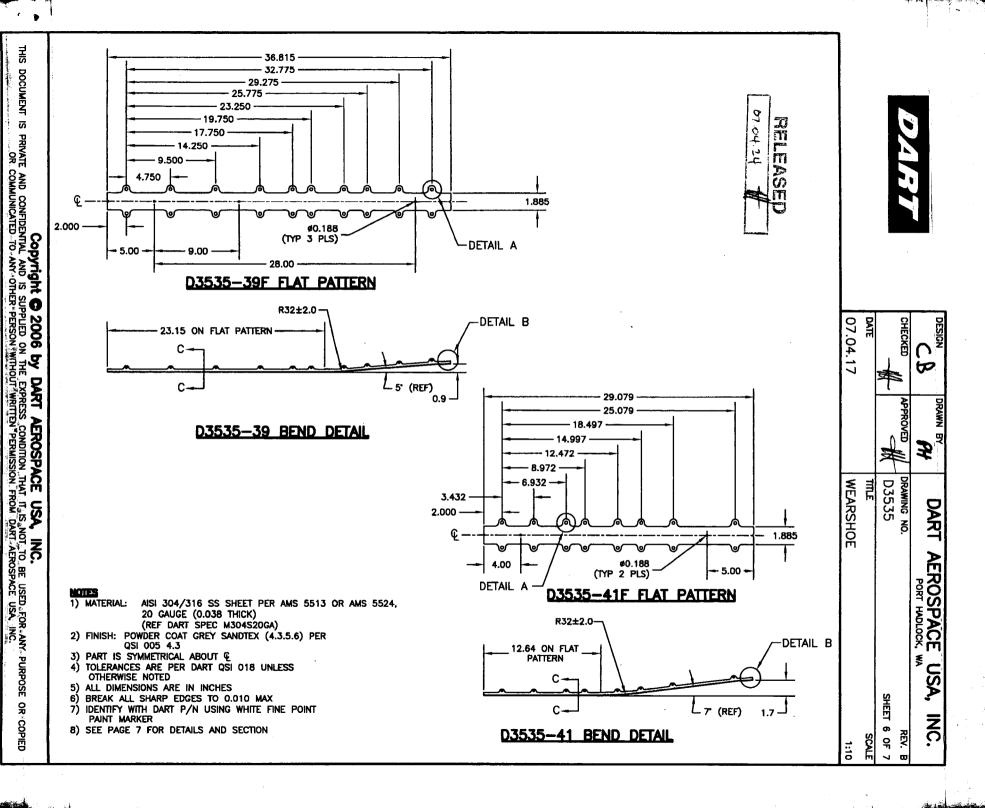
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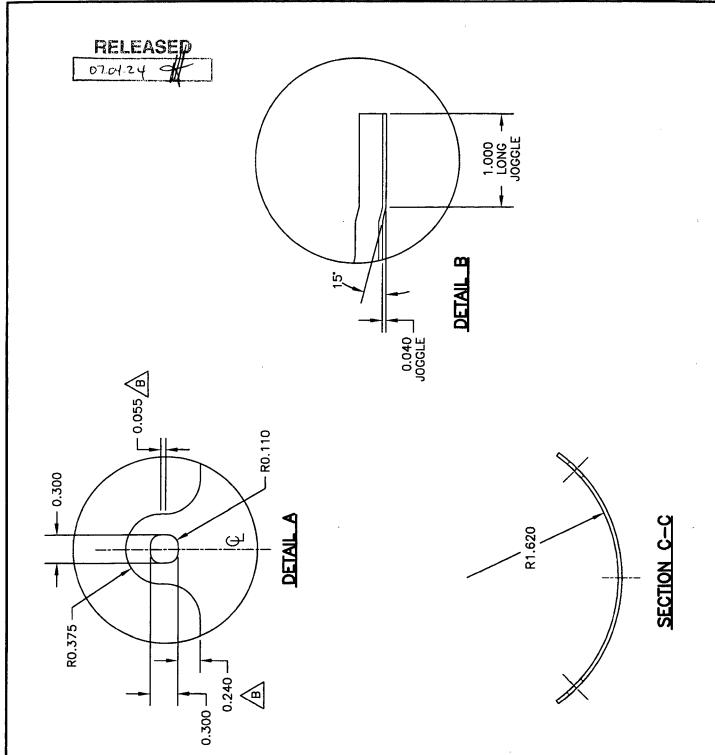
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
- (REF DART SPEC M304S20GA) 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER
- QSI 005 4.3
 3) PART IS SYMMETRICAL ABOUT &
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION







CB CB	DRAWN BY	DART	AEROSPACE USA, INC.
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		D3535	SHEET 7 OF 7
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